

Work Order ID 73565

Friday, September 02, 2011 10:08:41 AM



Page 1

Item ID: D3643-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 9/2/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3643

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3643 1: Dwg Rev: A Prog Rev: A 1:2-
Deburr if necessary

BSI-14-02



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

BSI-14-02

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subs



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: Date:

QC: Date:

Accept

Setup Start

Stop

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Customer:

Run Start

Stop

Tooling: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3643

0.00

0.00

8

So 11/10/02

140



Small Fab

Small Fab

Small Fab

Memo

C'sink as per Dwg D3643

0.00

0.00

SP 11/10/31 8

W 11/11/02 8

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8 BL 11-11-3.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8XPM 11/11/03

180

Identify as per dwg & Stock Location: 8T244A 0.00



Packaging

Memo

0.00

Packaging

8P 11-11-04

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/11/11

11/11/11

(8)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, September 02, 2011 10:08:39 AM

Page 1

Work Order ID: 73565

Parent Item: D3643-2

Parent Item Name: Stiffener



Start Date: 9/2/2011

Required Date: 9/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	172.0184	0.1475	0.931579			



2024-T3 .040 sheet



B11-10-22

Location

Loc Qty

Loc Code

MAT022

172.018421

112291

0.5

112331

0.2

113162

16.1

117684

155.218421

117684

8

W/O:		WORK ORDER CHANGES					
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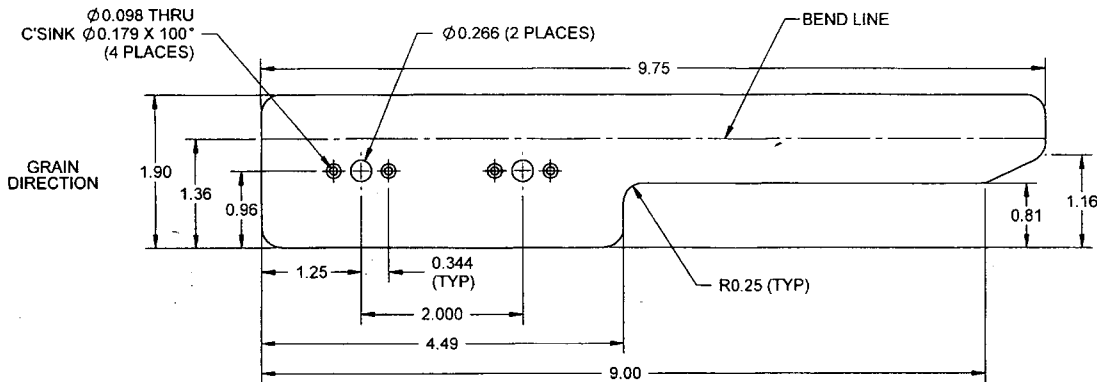
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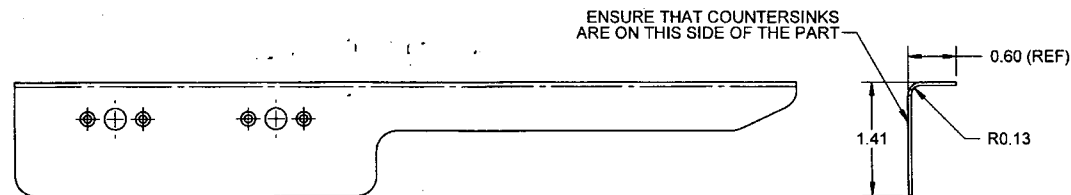
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D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)



D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs

A	NEW ISSUE; REPLACES G10610		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DTI	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3643 TITLE STIFFENER COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	REV. A	
DRAWN	CE		SHEET 1 OF 1	
CHECKED	EB		SCALE	
MFG. APPR.	EB		2:3	
APPROVED	EB			
DE APPR.	EB			
DATE	07.07.27			

W10 73565

RELEASED
07.09.07

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